

Date: Thursday, 11/9/2006 4:38:34 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 29404		
Estimate Number	: 11035		
P.O. Number	: <i>N/A</i>	Part Number	: D28032
This Issue	: 11/9/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2803 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28180	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/24/2006 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06 11 10		
Comment	: Est. A 00.11.06 New Issue EC Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total: 40.2507 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: *m101262**m 06 11 15**(20)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8533

Dwg Rev: *B*Prog Rev: *A**m 06 11 15**(20)*

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

JL / 06/11/20 19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / 06/11/20 19

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

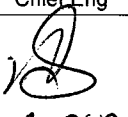

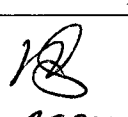

Er 06/11/21 x 19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/20

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/20	3	- 1 part is scrapped, marks from water jet were left on part "did not completely clean". Marks are too deep to polish out.		- scrap - no replace destroy give to eng	J.L. 06/11/20	 06/11/20	 06/11/20	 06/11/20

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:38:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 29404

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

3.1 / 06/11/20 X19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/11/21 X19

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

f.c. 9/06/11/23 X 19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ST154 04/11/27 (4) Took SB 06/11/24 15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 06/11/29 (15)

Job Completion



W 06.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29404
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

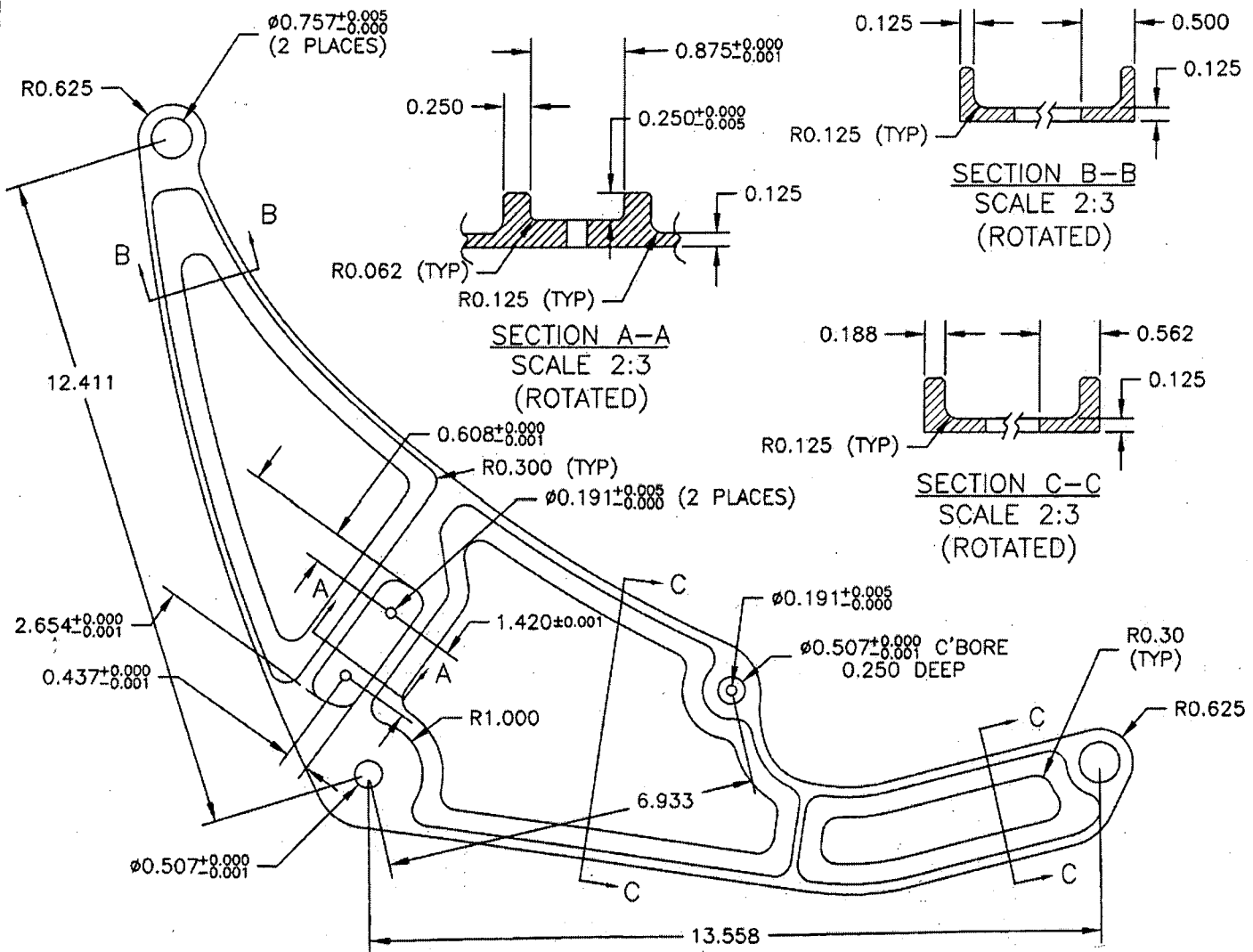
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.7585	✓			
1.420	+/-0.001	1.420	✓			
Ø0.191	+0.005/-0.000	.193	✓			
Ø0.507	+0.000/-0.001	.5062	✓			
Ø0.507 x 0.250	+0.000/-0.001	.5065 x .248	✓			
12.411	+/-0.010	12.411	✓			
13.558	+/-0.010	cant measure				
6.933	+/-0.010	6.932	✓			
0.250	+/-0.010	.248	✓			
0.875	+0.000/-0.005	.875	✓			
0.250	+0.000/-0.005	.246	✓			
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.126	✓			
0.500	+/-0.010	.501	✓			
0.125	+/-0.010	.126	✓			
0.188	+/-0.010	.188	✓			
0.562	+/-0.010	.563	✓			
0.125	+/-0.010	.126	✓			

Measured by:	J.L	Audited by:	EP	Prototype Approval:	N/A
Date:	06/11/17	Date:	06/11/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803
DATE	04.11.22	TITLE	STA 84 BRACKET	REV. B SHEET 1 OF 2
A	00.11.07	NEW ISSUE		SCALE 1:3
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)**



- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO 29404

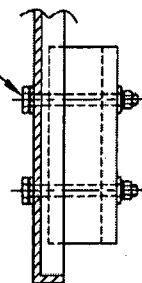
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)

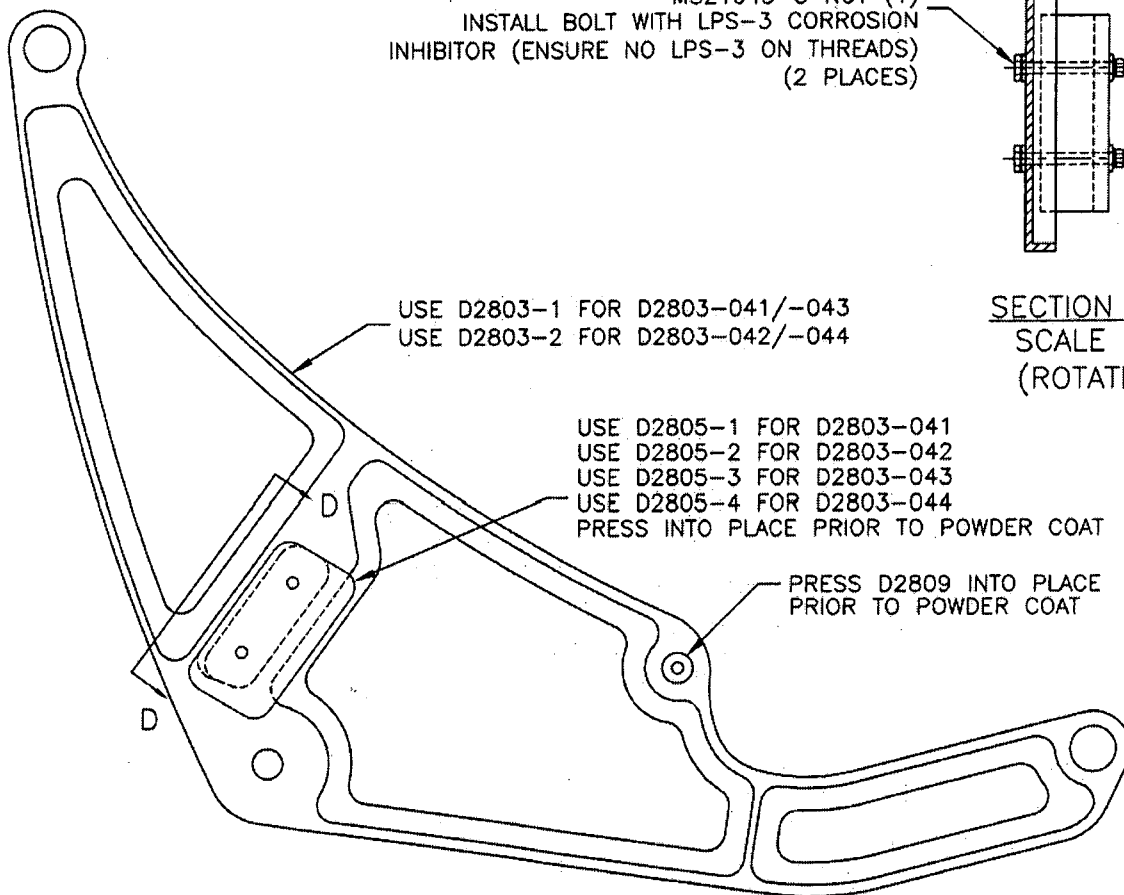


SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT



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NO. 29404

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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